

Date: Thursday, 27/11/2008 2:25:38 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 43819A		
Estimate Number	: 10206		
P.O. Number	:	Part Number	: D2989041
This Issue	: 27/11/2008 S.O. No. :	Drawing Number	: D2989 REVC
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / /	Drawing Revision	: C
Previous Run	: 43789	Material	:
Written By	:	Due Date	: 20/12/2008
Checked & Approved By	: <u>JLD 08.11.27</u>	Qty:	1 Um: Each
Comment	Est Rev:I Removed D2989-043 05-11-03 JLM Est Rev:J 08-08-29 revC as per dwg DD verified by:EC Est Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: 341717

SAD

08.12.16

①

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets 340895

Cpl 08.12.16

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing 339560

Cpl 08.12.16

4.0	D2506	Label Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate 339457

Cpl 08.12.16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:25:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43819A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 15.0000 sf(s)/Unit Total : 15.0000 sf(s)

Pick:

Qty Part number

Description Batch

15sf M304EX0.75-16F Expanded Metal

M109389

SAD 08-12-11 (1)

6.0

M304TS0750W065

304 SQ Tube .75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total : 31.7709 f(s)

3/4" x 3/4" x 0.065" wall 304/316 SStubing.

Batch: B109731

SAD 08-12-11 (2)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

SAD 08-12-11 (3)

P70

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

POWDER COATING

POWDER COATING



M109996



(1X)

Comment: POWDER COATING






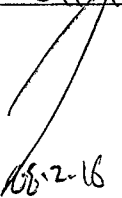

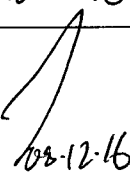
1- Plug holes in D2581 prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

M-L 08/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2989-041 PAR #: N/A Fault Category: Prod/FAB. Large NCR: (Yes) No DQA: 1 Date: 08/12/19
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: 1 Date: 08/12/30

NCR: 43819A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08-12-16	7.0	Qty 2 of the D2327-3 Bushings & 2x D3836-041 are scrap. Hole was predrilled in the incorrect location. Should be 6", but the bushings were welded at 6.125", and will result in the lid opening lower.		New jig is being made DT9447	LPL 08-12-18	S 8/12/19		
				Scrap, destroy & replace	LPL 08-12-16	S 8/12/19		
		R. C. Employee did not have drill the hole in the correct location.						

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:25:39 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 43819A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: m/109195

Wing Walk: m/139219

FL 08/12/23 (1K)

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30 OF
3:40-00
3:00
3:15 OF
4:00
3:45

M 08/12/22 (1)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

FL 08/12/23 (1)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/24

Job Completion



U 08.12.23

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

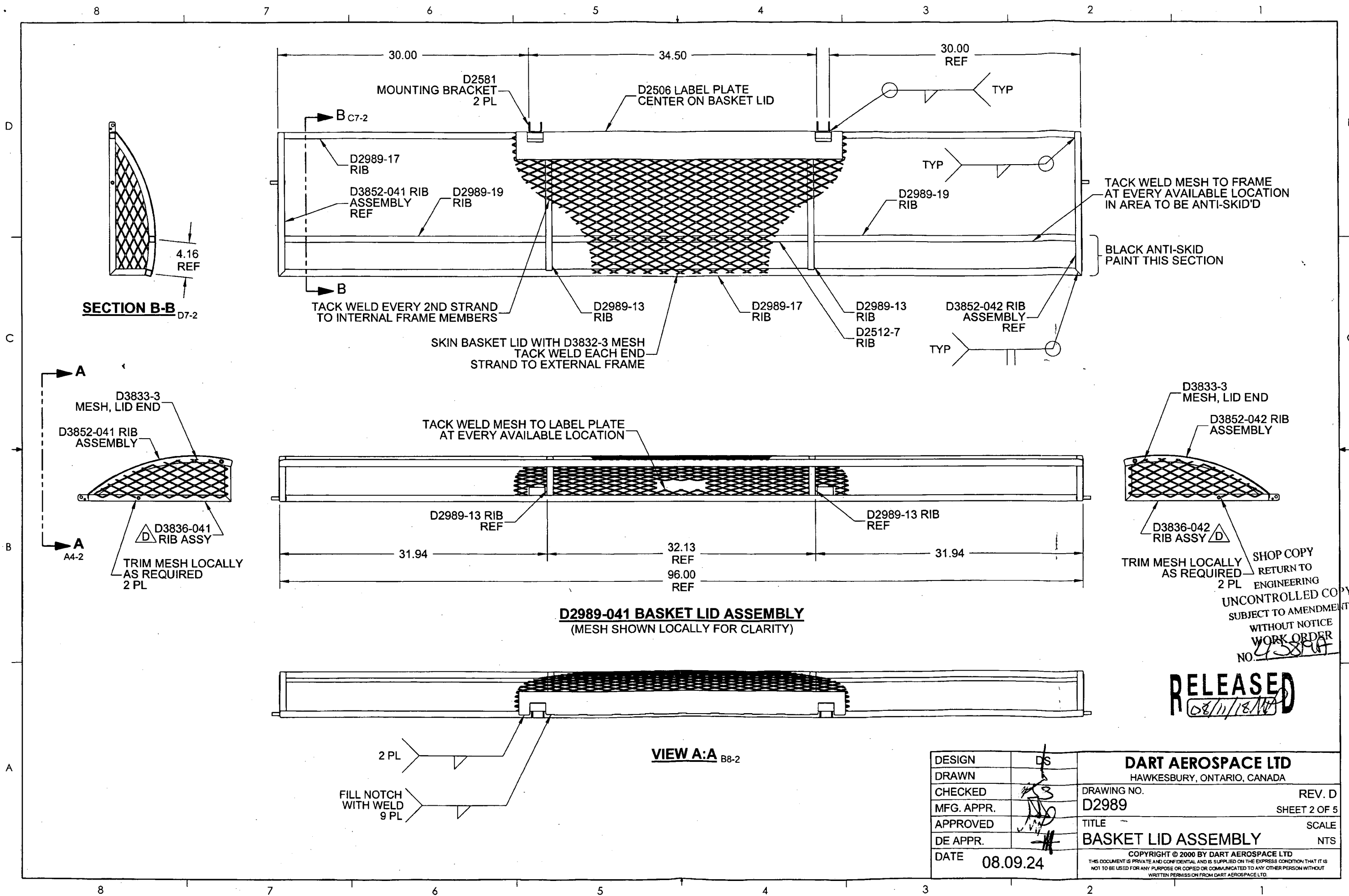
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
 - 8) WELD PER DART QSI 004

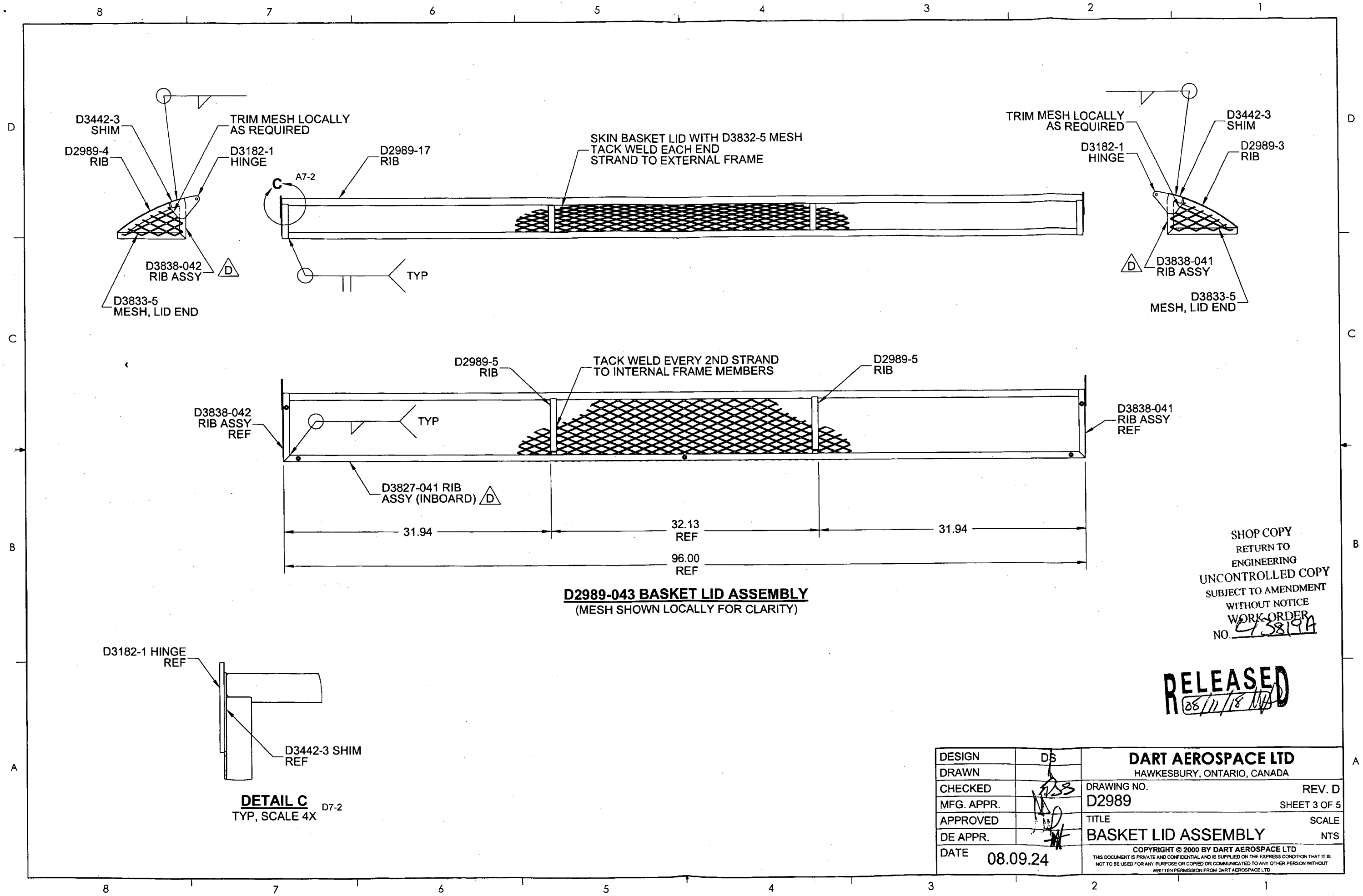
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D2989-041	BASKET LID ASSEMBLY
2		X	D2989-043	BASKET LID ASSEMBLY
3	1		D2506	LABEL PLATE
4	1		D2512-7	RIB
5	2		D2581	MOUNTING BRACKET
6		1	D2989-3	RIB
7		1	D2989-4	RIB
8		2	D2989-5	RIB
9	2		D2989-13	RIB
10	2	1	D2989-17	RIB
11	2		D2989-19	RIB
12		2	D3182-1	HINGE
13		2	D3442-3	SHIM
14		1	D3827-041	RIB ASSY (INBOARD)
15	1		D3832-3	MESH, BASKET LID
16		1	D3832-5	MESH, BASKET LID
17	2		D3833-3	MESH, LID END
18		2	D3833-5	MESH, LID END
19	1		D3836-041	RIB ASSY (BASKET LID, LH)
20	1		D3836-042	RIB ASSY (BASKET LID, RH)
21		1	D3838-041	RIB ASSY (BASKET LID, LH)
22		1	D3838-042	RIB ASSY (BASKET LID, RH)
23	1		D3852-041	RIB ASSEMBLY
24	1		D3852-042	RIB ASSEMBLY

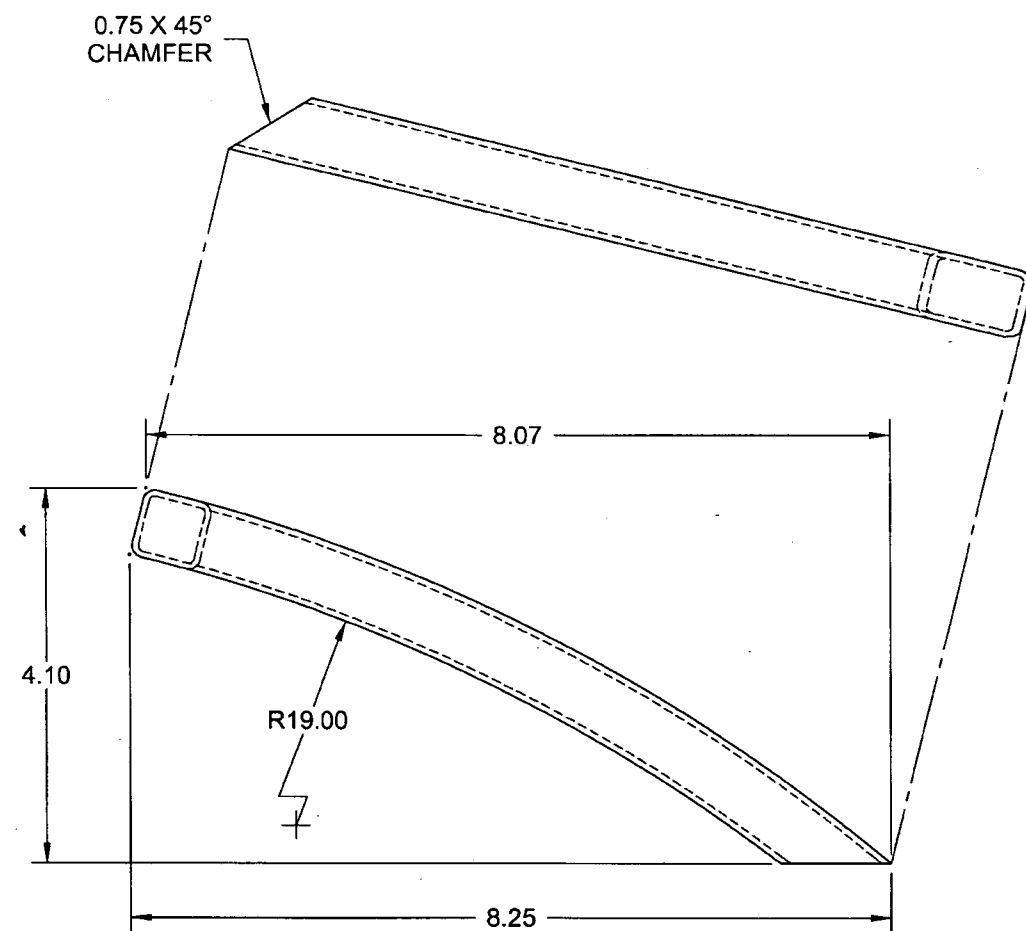
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WORK ORDER
NO. 4389A

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08/11/18

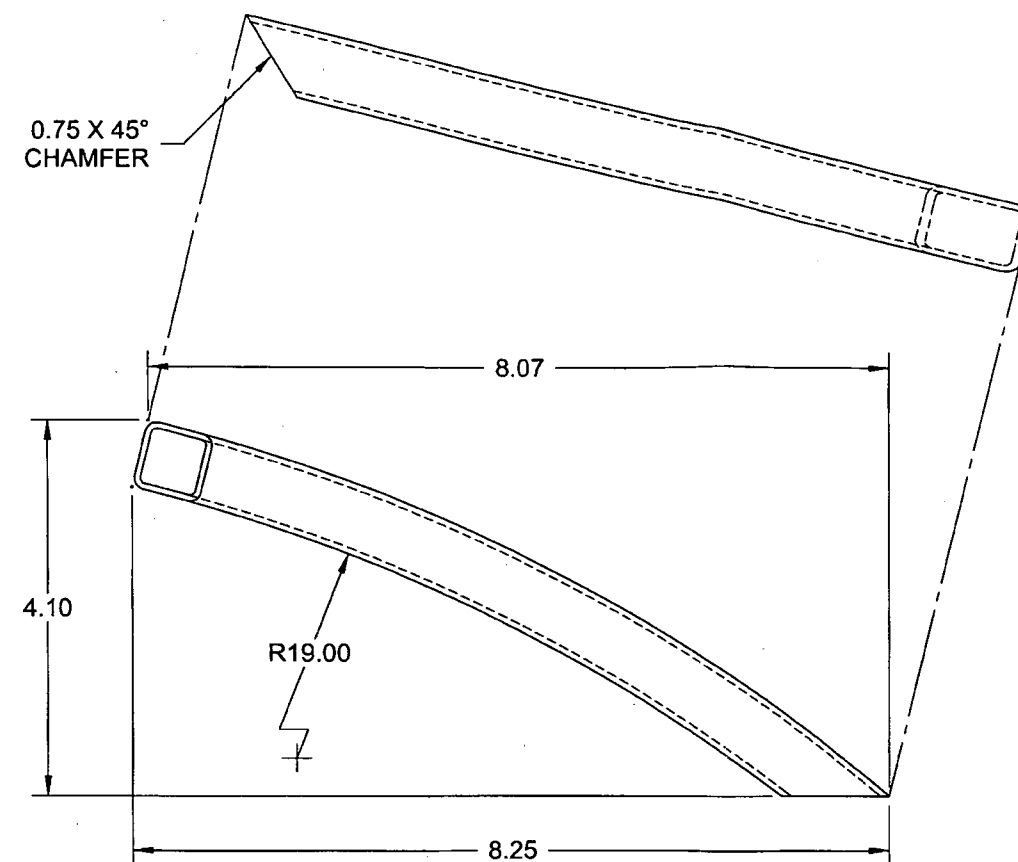
D	REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2; REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM	MB	08.09.24
C	FRAME MATERIAL WAS 0.060 WALL; MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD	AJS	08.06.20
B	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	PH	05.06.07
A	NEW ISSUE	DS	00.10.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ass	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
DATE	08.09.24	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	







D2989-3 RIB

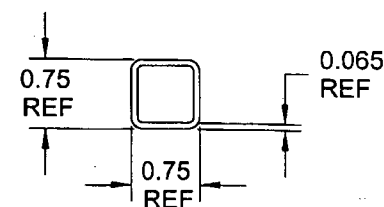


D2989-4 RIB





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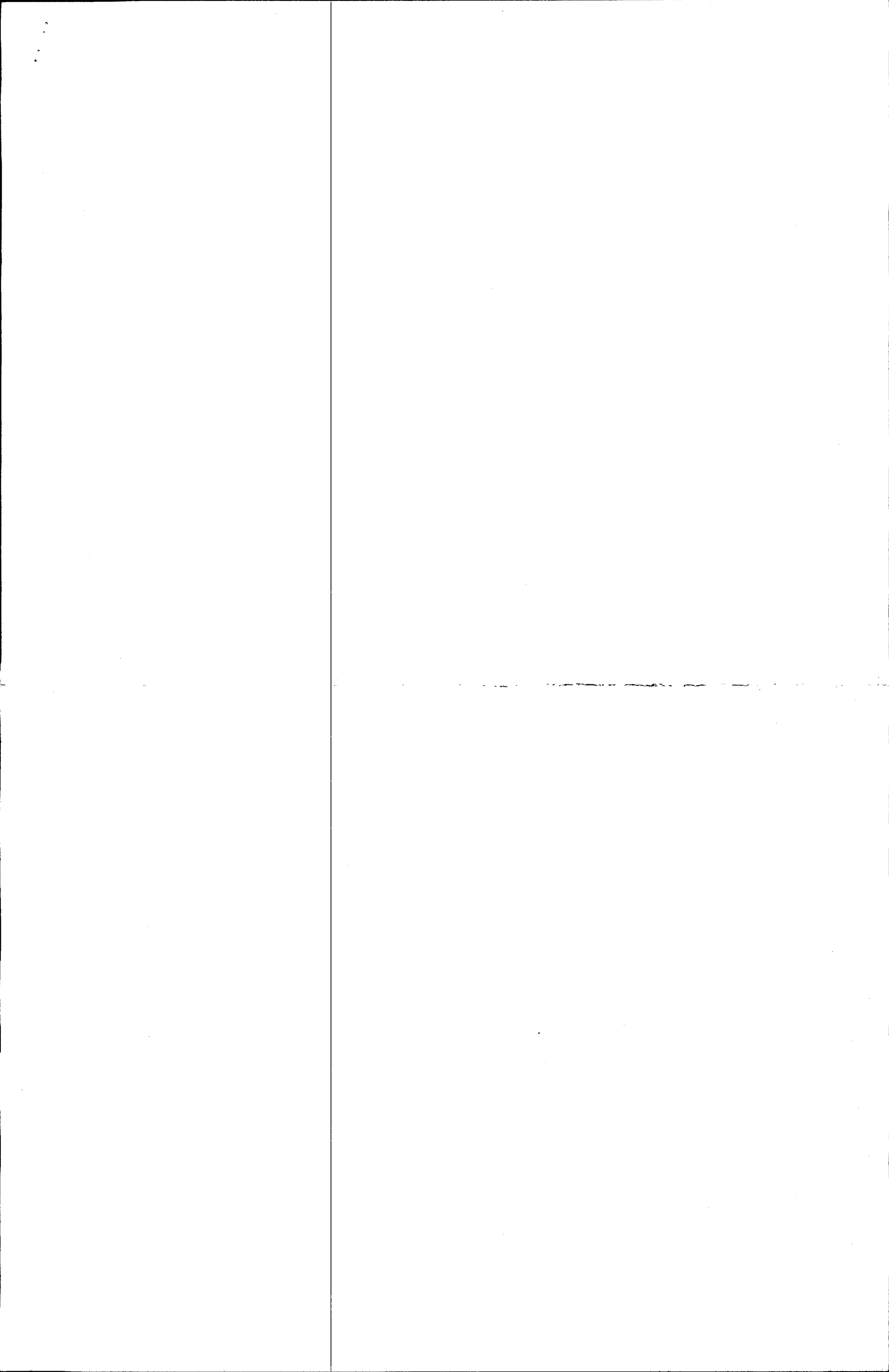
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08/11/18 NW

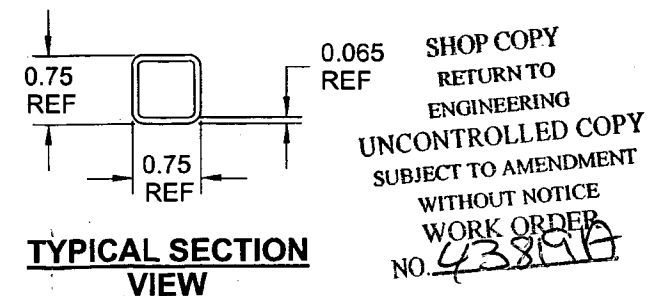
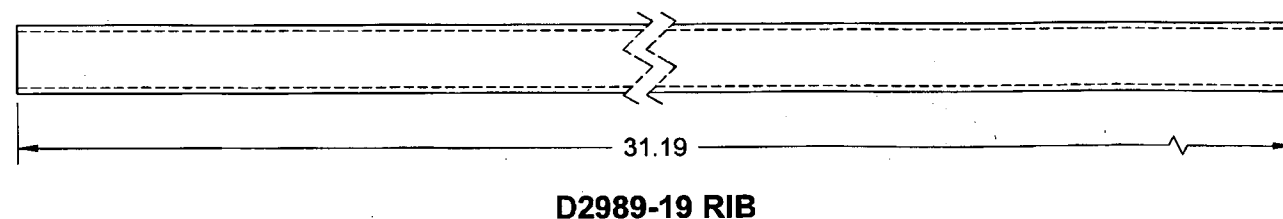
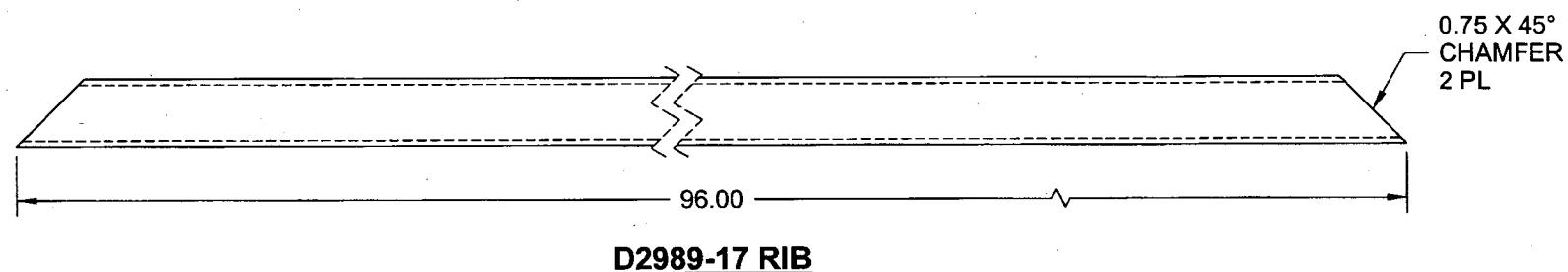
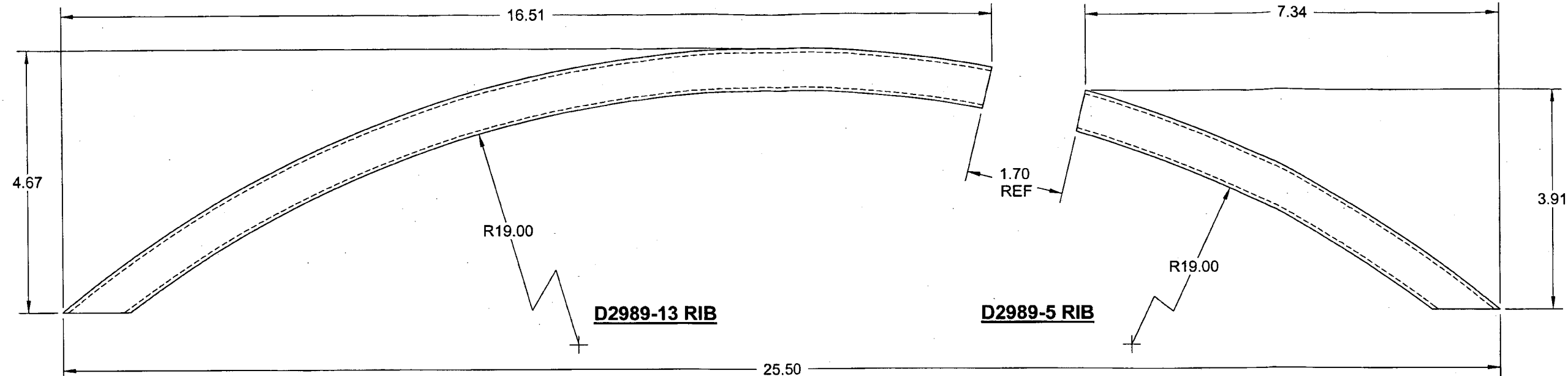
- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;



**TYPICAL SECTION
VIEW**

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 4 OF
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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TYPICAL SECTION VIEW

RELEASED
08/11/18

- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
 REF. DART SPEC. M304TS0.750W0.065
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DS	DRAWING NO.	REV. D
MFG. APPR.		D2989	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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